

Work Order ID 57156

March 24, 2010 8:43:12 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 07/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *2013-24* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A *AG*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R □ Aluminum Rod □

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

> DP 10-3-30

BE 10-3-30

BE 10-3-30

> DP 10-3-31

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1 - - AWM 10-3-31

130

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 10-3-31 Time: 10:15

Finish Date: 10/4/5 Time: 7:30AM

A/R Sikaflex-291 112429

Sikaflex expiry date:

10-5-20

AWM -10-3-31

AWM

-10-3-31

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sobulos

Memo

0.00

60

150



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod ☒ *M112507*

BE 10/04/05

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

DP
10-04-06

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

BR 10-4-7 ①

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M113170

Memo

0.00

Powder Coating

START TIME: 10:45AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:15AM

⇒ 10/04/07

XL ①

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-4-7 ①

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<p>Memo</p> <p>1-Install inserts & wearpads as per Dwg D2622. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>M113463</u> Sikaflex expiry date: <input type="checkbox"/> <u>10/08.</u></p> <p>2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive</p> <p>3-Install MS27039-4-06 Screw as per DEO 9153</p> <p>4-Inspect for foreign object per QSI 024</p> <p>5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>M113463</u> Sikaflex expiry date: <input type="checkbox"/> <u>10/08.</u></p> <p>6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 <input type="checkbox"/> Batch: <u>M113463</u></p>	0.00							

BF 10-4-8 ①

W/O:		WORK ORDER CHANGES					
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Start Date: 24/03/2010 Start Qty: 1.00

Required Date: 07/04/2010 Req'd Qty: 1.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	8/10/04/08						
240  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/10/04/08			(X)			
250  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location: _____ PPP Rev: _____	0.00 0.00							

PPN 57158

B 10/4/08 (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 *[Signature]*
mf
10-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March 24, 2010 8:43:16 AM

Page 1

Work Order ID: 57156

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416		Purchased	No				Each	8.0000	1.0000			
Washer												

Warehouse			Loc Qty	Loc Code
Location				
Main Warehouse				
ST357			8	
111279			8	
CCR264SS3-3	Purchased	No	Each	513.0000 2.0000
Cherry Rivet				

NAS 1149 D0463J.

1 BR 10-4-8.

Warehouse			Loc Qty	Loc Code
Location				
Main Warehouse				
ST311			513	
111548			16	
111827			1	
112314			2	
113539			6	
113973			488	
CR3212-4-03	Purchased	No	Each	236.0000 2.0000
Cherry Rivet				

10-4-6

2

Warehouse			Loc Qty	Loc Code
Location				
Main Warehouse				
ST311			236	
111359			84	
112314			152	

10-4-6

2

W/O:		WORK ORDER CHANGES					
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IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2620	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route	Unit of Each	Qty on 8.0000	Remaining 1.0000	Qty	Date	Status
Skidtube, 206 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55559

8

8

Each

87.0000

1.0000



DD 10-3-30

D2647



Cap

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55352

87

87

Each

207.0000

19.0000



1 BE 10-3-30

D2649



Cross Bolt Spacer

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

207

36013

5

47112

18

48271

4

51529

3

55000

177

19 BE 10/04/05

March 24, 2010 8:43:16 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2654-5		Manufactured	No				Each	2.0000	1.0000			
												
Web												

D2680-041



Nut Plate

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

46638

2

2

Each

51.0000

1.0000



B-57241- AWM 10-3-31 1

ALS4-1032-130



Insert

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

33061

55366

51

1

50

220

Each

438.0000

54.0000



DP 10-4-6

ALS7-1032-130

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

110511

438

438

113238

54. 10-4-8.

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Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10L		Purchased	No			220	Each	0.0000	54.0000			
												
washer												
AN960JD10L		Purchased	No			220	Each	3,003.000	2.0000			
												
Washer												

UAS1149C0332R

113524



34 BR 10-4-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

3003

101291

16

105793

49

110985 ✓

2938

2 BR 10-4-8

D2646

Manufactured No

220

Each

41.0000

1.0000



Aft Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

36

46327

4

48109

4

52663

28

Main Warehouse

fp7

5

52663 ✓

5

1 BR 10-4-8

March 24, 2010 8:43:16 AM

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2651-1		Manufactured	No			220	Each	348.0000	14.0000			
Plug												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

141

51530 ✓

141

Main Warehouse

fpa

207

53349

207

D2651-3

Manufactured No



O-Ring

220

Each

537.0000

14.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

537

43849

3

46114 ✓

534

H. BL 10-4-8.

14. BL 10-4-8

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 24, 2010 8:43:16 AM

Page 6

Work Order ID: 57156

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3535-11		Manufactured	No			220	Each	6.0000	1.0000			
												
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

46647 ✓

6

6

D3535-23

Manufactured No

220

Each

14.0000

1.0000



Wearshoe

1 BR 10-4-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

53467 ✓

56054

14

2

12

D3535-35

Manufactured No

220

Each

9.0000

1.0000



Wearshoe

1 BR 10-4-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

51608 ✓

9

9

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Page 6

1 BR 10-4-8

W/O:		WORK ORDER CHANGES					
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Page 7

Work Order ID: 57156

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
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Start Date: 24/03/2010

Required Date: 07/04/2010



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3536-11		Manufactured	No			220	Each	14.0000	1.0000			
												
Gasket												



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST497A	14	
46649 ✓	10	
46715	4	

1 BR 10-4-8

D3536-23		Manufactured	No			220	Each	8.0000	1.0000			
												
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	8	
30754	1	
53468 ✓	7	

1 BR 10-4-8

D3536-35		Manufactured	No			220	Each	11.0000	1.0000			
												
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	11	
51628 ✓	11	

1 BR 10-4-8

March 24, 2010 8:43:16 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 8

Work Order ID: 57156

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3537-1		Manufactured	No			220	Each	53.0000	6.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 52
 48288 2
 55465 ✓ 50

Main Warehouse

FP17 1
 51678 1

D3537-3

Manufactured No



Wearpad

220 Each 24.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 24
 33881 4
 35697 ✓ 20

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Page 8

6 PR 10-4-8

1 PR 10-4-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 9

Work Order ID: 57156



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 24/03/2010

Required Date: 07/04/2010

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------



Screw

Purchased

No

220

Each

2,105.000

56.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291

2105

110467

3

110552

102

110835 ✓

2000

MS27039-4-06



Screw

Purchased

No

220

Each

38.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST292

38

109061 ✓

38

56 BR 10-4-8

1 BR 10-4-8.

W/O:		WORK ORDER CHANGES					
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57154

BS10-3-24

RELEASED
08-07-23/17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	JP	D2650	SHEET 1 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	206/407 SKIDTUBE ASSEMBLIES	NTS
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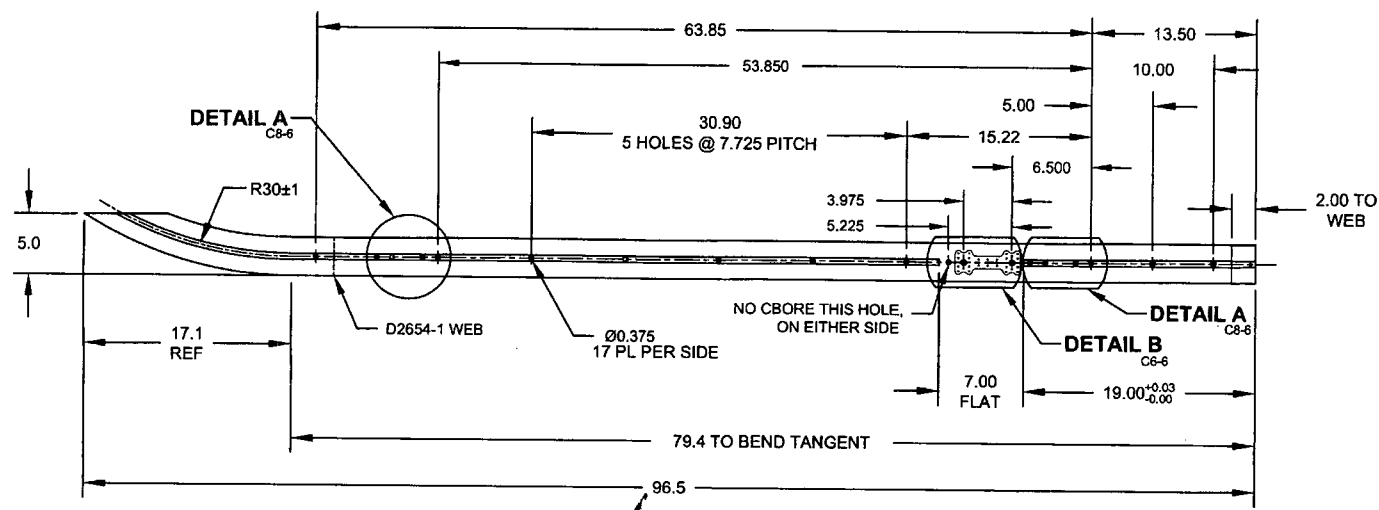
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

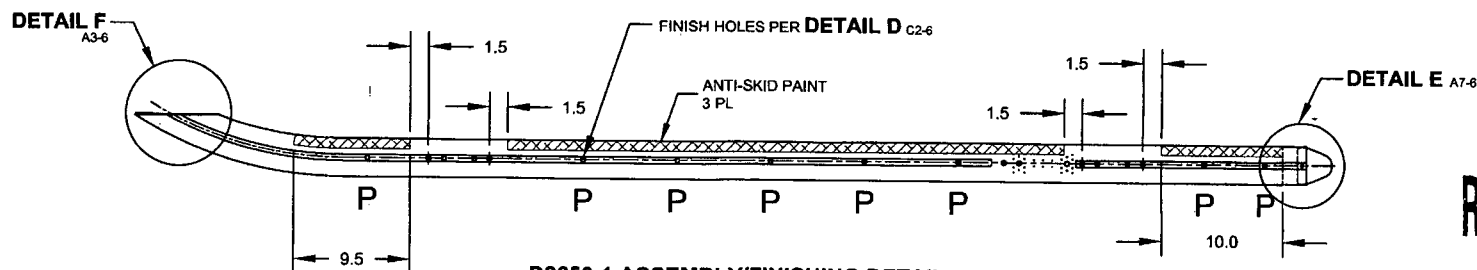
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NOTE: Date & initial all entries







D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
680922/117

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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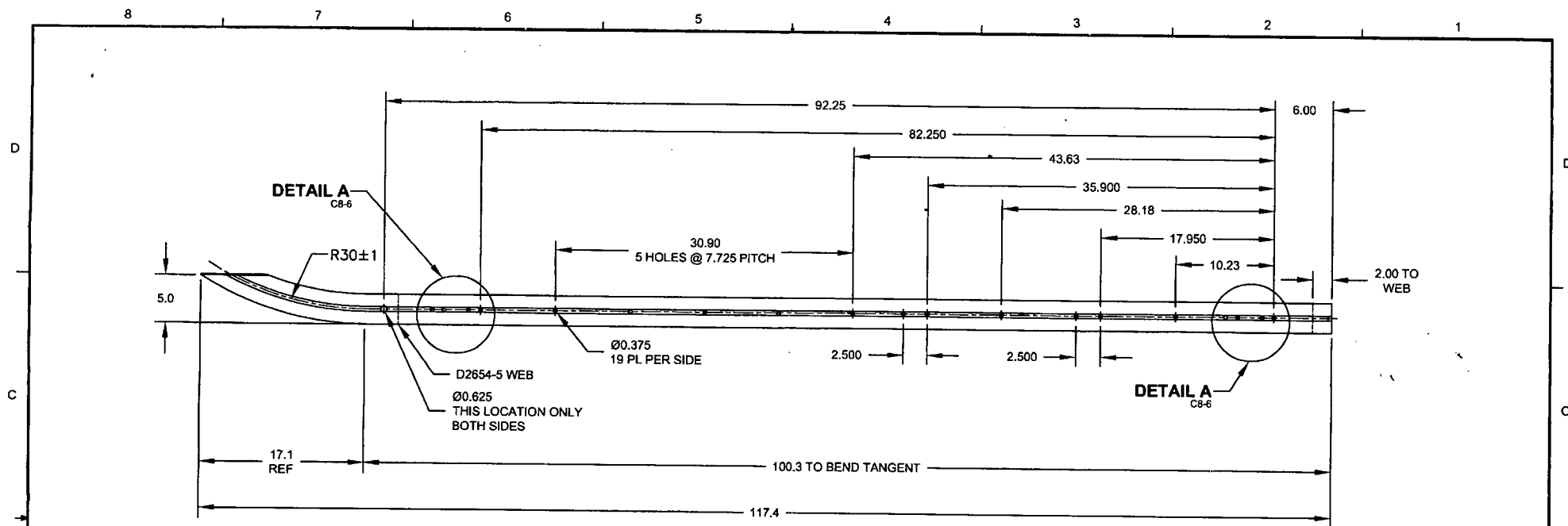
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

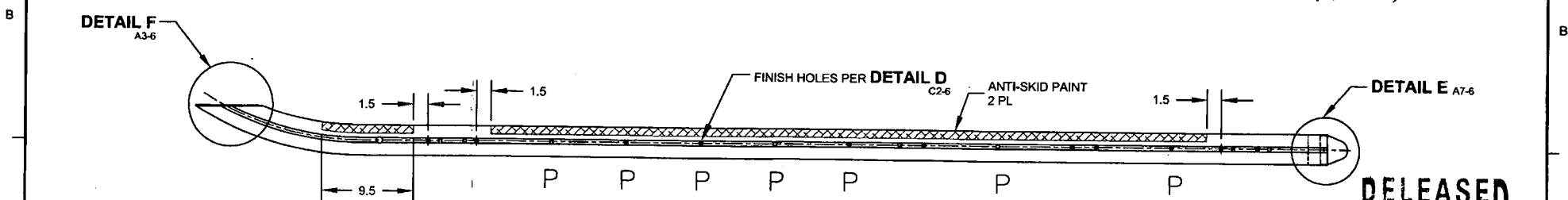
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
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08.09.22/117

57154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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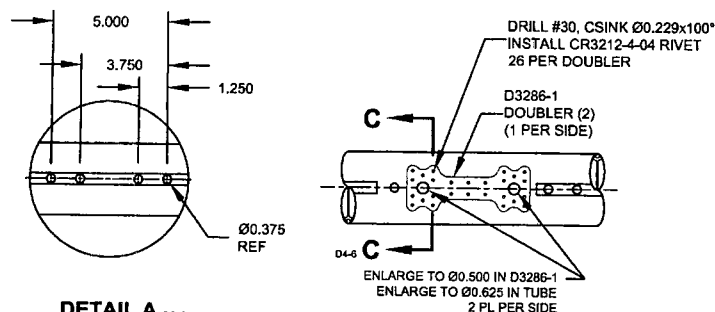
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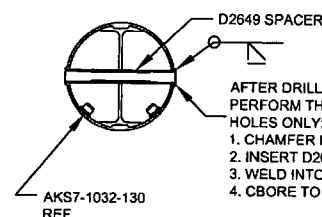
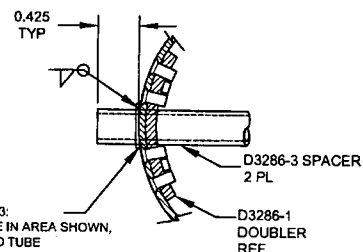


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

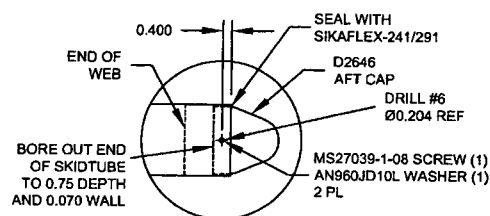
DETAIL B
SCALE 2X
C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

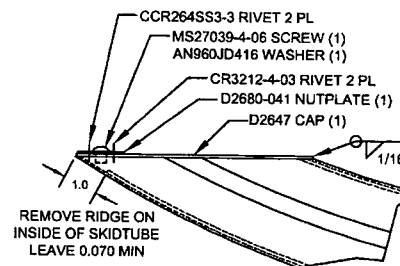
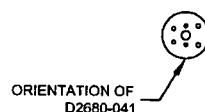
SECTION C-C C7-6
SCALE NONE



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5






DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B6-2
B6-3
B6-4
B6-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-2018

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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NO. 323

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job number: SS777
Part number: 0206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rat. Suf Date of Test Coupon 10.02.16
Welder Bardley Elliott Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld